

Work Order ID 146172

146172

Page 1

May 09, 2016 1:45:04 PM

Item ID: D5085-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Web

Stop

NS2

Start Date: 5/9/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/16/2016 Req'd Qty: 6.00

6

Customer:

Reference:

20160509

Approvals:

Process Plan: *SLA*

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5085

A

100

0.00

100

Purchasing

Purchasing

Memo

Purchasing

Issue P/O:

32459

Supplier: WEJAY.

Machine as per Dwg D5085

Conformity sheet required

0.00

MAY 23 2016

DAS

13

9-09

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.12

160616

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only, ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Work Order ID 146172

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146172

Page 2

Item ID: D5085-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web
 Start Date: 5/9/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 5/16/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS
120									9
QC	Memo	0.00							9-89
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	1.38							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.06							
Quality Control									

> 16-6-20 H.G. BE

16-6-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 146172

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146172

Page

Item ID: D5085-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Web

Stop

NS2

Start Date: 5/9/2016

Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/16/2016

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: L6002

0.00

150

Packaging

Memo

0.06

Packaging

16-6-20 Rel.


160

QC21- Final Inspection - Work Order Release

0.00

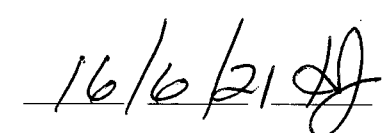
160

QC

Memo

0.60

Quality Control

16/6/21 Rel.


DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Picklist Print

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Page 1

Work Order ID: 146172

146172

Parent Item: D5085-1

D5085-1

Parent Item Name: Web

Start Date: 5/9/2016

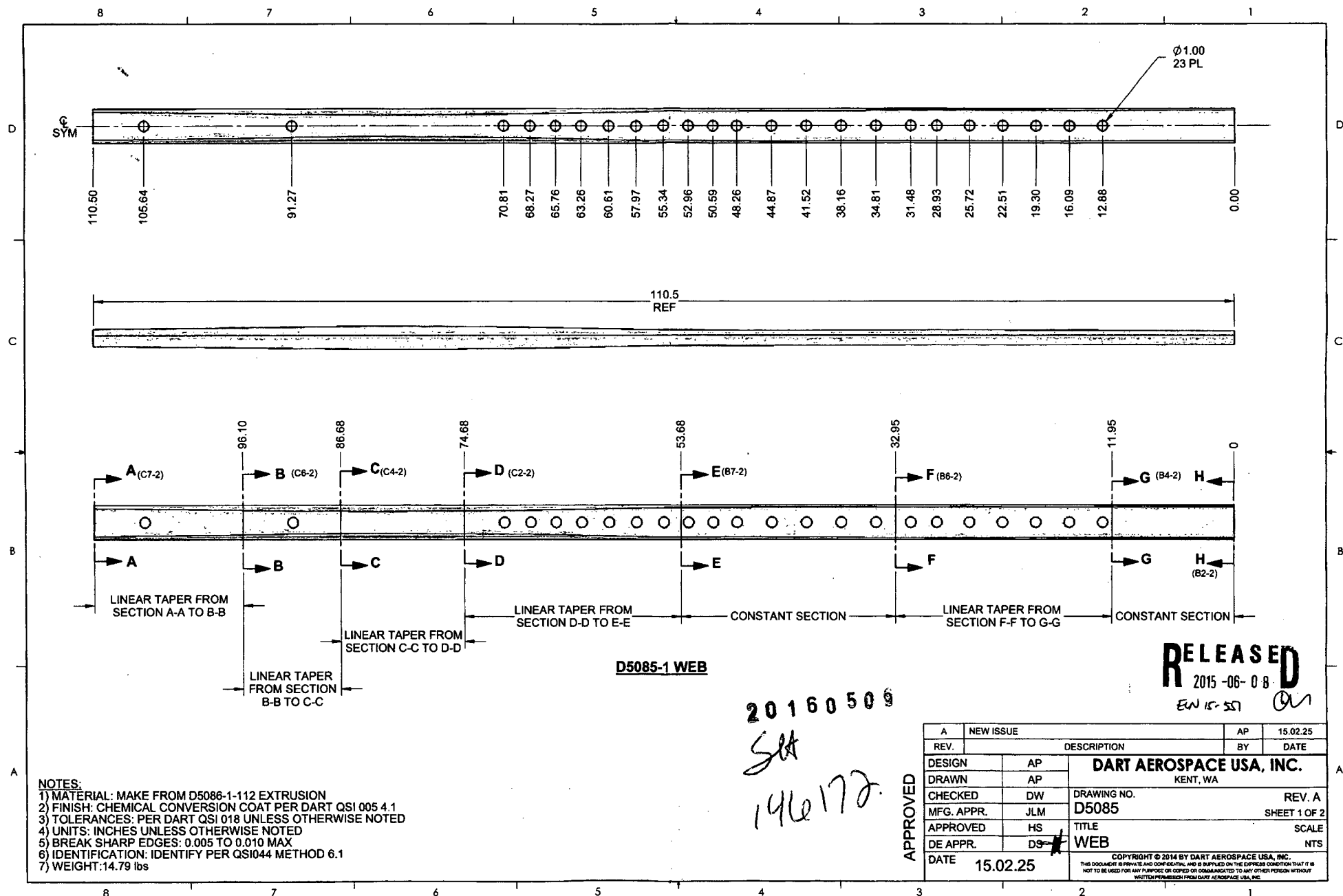
Required Date: 5/16/2016

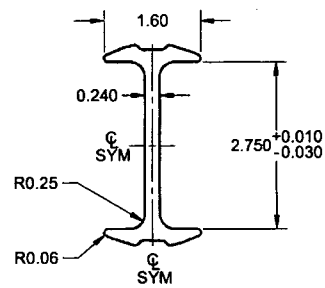
Start Qty: 6.00

Required Qty: 6.00

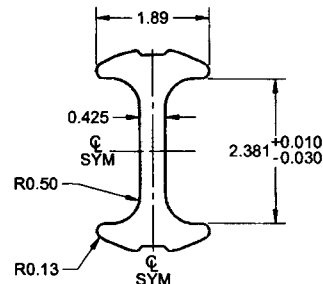
Comments: IPP REV:A NEW ISSUE 14-10-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5085-1P		Purchased	No				Each	0.0000		6			
D5085-1P									**				
Web													
D5086-1-180		Manufactured	No				Each	6.0000		6			
D5086-1-180									**				
Extrusion 180" Long													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				HALL		6							
				123994		6							

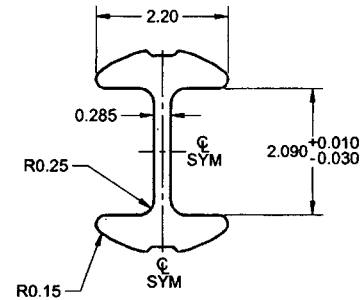




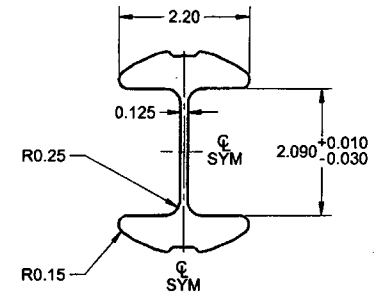
SECTION A-A (B8-1)
SCALE 4X



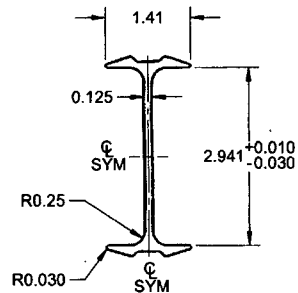
SECTION B-B (B7-1)
SCALE 4X



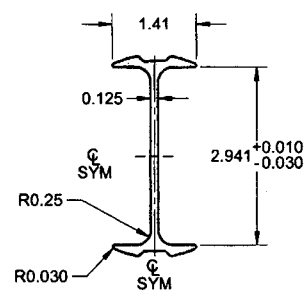
SECTION C-C (B7-1)
SCALE 4X



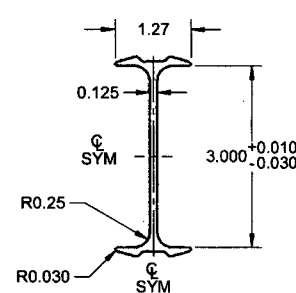
SECTION D-D (B6-1)
SCALE 4X



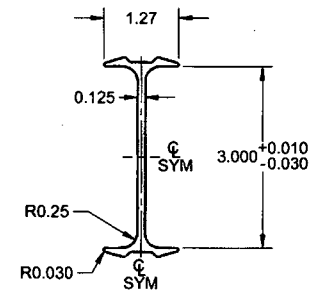
SECTION E-E (B4-1)
SCALE 4X



SECTION F-F (B3-1)
SCALE 4X



SECTION G-G (B2-1)
SCALE 4X



SECTION H-H (B1-1)
SCALE 4X

RELEASED
2015-06-08

APPROVED

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	DW	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5085	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
DATE	15.02.25	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

Purchase Order Date 5/24/2016
PO Print Date 5/24/2016

Page Number 1 of 2

Order From :
WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

VC-WMP001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

MAY 25 2016

Contact Name
Vendor Phone 613-384-1662

Ship To Contact
Ship To Phone
Ship Via: Journey Freight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D5085-1P AS PER DWG D5085 REV. A B146172	Web	6/20/2016 Yes 6/20/2016	FN	6.00 Each	\$945.00	\$5,670.00
						Line Total:	\$5,670.00
2	71401-45 Procurement Quality Clauses	PROCUREMENT QUALITY CLAUSES	6/20/2016 No 6/20/2016		1.00	\$0.00	\$0.00

Note:

5/24/2016

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION

[illegible]

(3)

1990



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: June 13, 2016	
		P.O.# PO32459	
		WEJAY JOB# 38025	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D5085-1P 'Web' B146172	6	Machined eomplete per drawing req'ts.	D5085 / rev. C
Note: 1) Material: Aluminum extrusions supplied by Dart Aerospace. 2) 1st Article and Final Inspection/ Test Reports attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith
Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 38025

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO32459

PART No. D5085-1

DESCRIPTION: Web

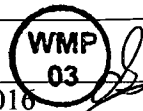
DWG No. D5085 - sheets 1-2

REV. A

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR:
Paul Roosen



QUANTITY
REC'D: 1

ACCEPT:
1

REJECT
--

N.C.R.#
--

DATE: June 6, 2010

INSTRUCTIONS, COMMENTS: **FIRST ARTICLE INSPECTION** / FINAL INSPECTION

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	110.5	O.A. length	±.03	1_C4	110.5	1	Accepted
2	Hole, Diameter 1.00	23 places	+0.010/-0.001	1_D1	1.002 typ.	1	Accepted
3	12.88		±.03	1_D2	12.880	1	Accepted
4	16.09		±.03	1_D2	16.09	1	Accepted
5	19.30		±.03	1_D2	19.299	1	Accepted
6	22.51		±.03	1_D2	22.508	1	Accepted
7	25.72		±.03	1_D3	25.719	1	Accepted
8	28.93		±.03	1_D3	28.904	1	Accepted
9	31.48		±.03	1_D3	31.480	1	Accepted
10	34.81		±.03	1_D3	34.812	1	Accepted
11	38.16		±.03	1_D3	38.162	1	Accepted
12	41.52		±.03	1_D4	41.522	1	Accepted
13	44.87		±.03	1_D4	44.873	1	Accepted
14	48.26		±.03	1_D4	48.262	1	Accepted
15	50.59		±.03	1_D4	50.590	1	Accepted
16	52.96		±.03	1_D4	52.959	1	Accepted
17	55.34		±.03	1_D5	55.343	1	Accepted
18	57.97		±.03	1_D5	57.971	1	Accepted
19	60.61		±.03	1_D5	60.611	1	Accepted
20	63.26		±.03	1_D5	63.265	1	Accepted
21	65.76		±.03	1_D5	65.763	1	Accepted
22	68.27		±.03	1_D5	68.374	1	Accepted
23	70.81		±.03	1_D6	70.812	1	Accepted
24	91.27		±.03	1_D7	91.275	1	Accepted
25	105.64		±.03	1_D8	105.642	1	Accepted
26	Sym to centerline		±.03	1_D8	O.K.	1	Accepted
SECTION A-A							
27	110.5	Loc'n of section	±.03	1_C7	110.501	1	Accepted
28	2.750	2 pl.	+0.010/-0.030	2_D7	2.748	1	Accepted
29	R 0.25	4 pl.	±.03	2_D8	R .250 typ.	1	Accepted

INSPECTION / TEST REPORT					JOB No. 38025		
					PAGE: 2 of 3		
CUSTOMER: Dart Aerospace							
CUST. P.O. PO32459							
PART No. D5085-1			DESCRIPTION: Web				
DWG No. D5085 - sheets 1-2			REV. A		E.C.O. --		
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

30	1.60	2 pl.	±.03	2_D7	1.612 typ.	1	Accepted
31	.240		±.01	2_D8	.240	1	Accepted
32	R .06	4 pl.	±.03	2_C8	R .06 typ.	1	Accepted

SECTION B-B

33	96.10	Loc'n of section	±.03	1_C7	O.K.	1	Accepted
34	2.381	2 pl.	+ .010/- .030	2_D5	2.383 typ.	1	Accepted
35	R 0.50	4 pl.	±.03	2_D6	R .50 typ.	1	Accepted
36	1.89	2 pl.	±.03	2_D6	1.889 typ.	1	Accepted
37	.425		±.01	2_D6	.412	1	Accepted
38	R .13	4 pl.	±.03	2_D6	R .125 typ.	1	Accepted
39	Linear taper	Sect. A-A to B-B	-	1_B8	O.K.	1	Accepted

SECTION C-C

40	86.68	Loc'n of section	±.03	1_C6	O.K.	1	Accepted
41	2.090	2 pl.	+ .010/- .030	2_D3	2.093	1	Accepted
42	R 0.25	4 pl.	±.03	2_D4	R .25 typ.	1	Accepted
43	2.20	2 pl.	±.03	2_D4	2.195 typ.	1	Accepted
44	.285		±.01	2_D4	.284	1	Accepted
45	R .15	4 pl.	±.03	2_C4	R .15 typ.	1	Accepted
46	Linear taper	Sect. B-B to C-C	-	1_B7	O.K.	1	Accepted

SECTION D-D

47	74.68	Loc'n of section	±.03	1_C6	O.K.	1	Accepted
48	2.090	2 pl.	+ .010/- .030	2_D1	2.085 typ.	1	Accepted
49	R 0.25	4 pl.	±.03	2_D2	R .25 typ.	1	Accepted
50	2.20	2 pl.	±.03	2_D2	2.195 typ.	1	Accepted
51	.125		±.01	2_D2	.127	1	Accepted
52	R .15	4 pl.	±.03	2_C2	R .15 typ.	1	Accepted
53	Linear taper	Sect. C-C to D-D	-	1_B6	O.K.	1	Accepted

SECTION E-E

54	53.68	Loc'n of section	±.03	1_C5	O.K.	1	Accepted
55	2.941	2 pl.	+ .010/- .030	2_B7	2.940 typ.	1	Accepted
56	R 0.25	4 pl.	±.03	2_B8	R .25 typ.	1	Accepted
57	1.41	2 pl.	±.03	2_C7	1.403 typ.	1	Accepted
58	.125		±.01	2_B8	.128	1	Accepted
59	R .030	4 pl.	±.01	2_B8	R .030 typ.	1	Accepted
60	Linear taper	Sect. D-D to E-E	-	1_B5	O.K.	1	Accepted

INSPECTION / TEST REPORT						JOB No. 38025	
						PAGE: 3 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O. PO32459							
PART No. D5085-1				DESCRIPTION: Web			
DWG No. D5085 - sheets 1-2				REV. A		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

SECTION F-F							
43	32.95	Loc'n of section	±.03	1_C3	O.K.	1	Accepted
44	2.941	2 pl.	+ .010/- .030	2_B5	2.942 typ.	1	Accepted
45	R 0.25	4 pl.	±.03	2_B6	R .25 typ.	1	Accepted
46	1.41	2 pl.	±.03	2_C6	1.403 typ.	1	Accepted
47	.125		±.01	2_B6	.125	1	Accepted
48	R .030	4 pl.	±.01	2_B6	R .030 typ.	1	Accepted
49	Constant Section	Sect. E-E to F-F	-	1_B4	O.K.	1	Accepted
SECTION G-G							
50	11.95	Loc'n of section	±.03	1_C2	O.K.	1	Accepted
51	3.000	2 pl.	+ .010/- .030	2_B3	3.002 typ.	1	Accepted
52	R 0.25	4 pl.	±.03	2_B4	R .25 typ.	1	Accepted
53	1.27	2 pl.	±.03	2_C4	1.265 typ.	1	Accepted
54	.125		±.01	2_B4	.128	1	Accepted
55	R .030	4 pl.	±.01	2_B4	R .030 typ.	1	Accepted
56	Linear taper	Sect. F-F to G-G	-	1_B3	O.K.	1	Accepted
SECTION H-H							
57	0.00	Loc'n of section	±.03	1_C1	O.K.	1	Accepted
58	3.000	2 pl.	+ .010/- .030	2_B1	3.002 typ.	1	Accepted
59	R 0.25	4 pl.	±.03	2_B2	R .25 typ.	1	Accepted
60	1.27	2 pl.	±.03	2_C2	1.265 typ.	1	Accepted
61	.125		±.01	2_B2	.130	1	Accepted
62	R .030	4 pl.	±.01	2_B2	R .030 typ.	1	Accepted
63	Constant Section	Sect. G-G to H-H	-	1_B1	O.K.	1	Accepted



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 38025

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO32459

PART No. D5085-1

DESCRIPTION: Web

DWG No. D5085 - sheets 1-2

REV. A

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR:
Cliff Smith



QUANTITY
REC'D: 1

ACCEPT:
1

REJECT
--

N.C.R.#
--

DATE: June 13, 2016

INSTRUCTIONS, COMMENTS: FIRST ARTICLE INSPECTION / **FINAL INSPECTION**

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	110.5	O.A. length	±.03	1_C4	110.518	1	Accepted
2	Hole, Diameter 1.00	23 places	+0.010/-0.001	1_D1	.999- 1.000	1	Accepted
3	12.88		±.03	1_D2	12.879	1	Accepted
4	16.09		±.03	1_D2	16.090	1	Accepted
5	19.30		±.03	1_D2	19.301	1	Accepted
6	22.51		±.03	1_D2	22.511	1	Accepted
7	25.72		±.03	1_D3	25.721	1	Accepted
8	28.93		±.03	1_D3	28.931	1	Accepted
9	31.48		±.03	1_D3	31.479	1	Accepted
10	34.81		±.03	1_D3	34.806	1	Accepted
11	38.16		±.03	1_D3	38.155	1	Accepted
12	41.52		±.03	1_D4	41.516	1	Accepted
13	44.87		±.03	1_D4	44.867	1	Accepted
14	48.26		±.03	1_D4	48.258	1	Accepted
15	50.59		±.03	1_D4	50.589	1	Accepted
16	52.96		±.03	1_D4	52.959	1	Accepted
17	55.34		±.03	1_D5	55.342	1	Accepted
18	57.97		±.03	1_D5	57.970	1	Accepted
19	60.61		±.03	1_D5	60.610	1	Accepted
20	63.26		±.03	1_D5	63.264	1	Accepted
21	65.76		±.03	1_D5	65.760	1	Accepted
22	68.27		±.03	1_D5	68.270	1	Accepted
23	70.81		±.03	1_D6	70.807	1	Accepted
24	91.27		±.03	1_D7	91.280	1	Accepted
25	105.64		±.03	1_D8	105.648	1	Accepted
26	Sym to centerline		±.03	1_D8	≤.002 t.i.r.	1	Accepted
SECTION A-A							
27	110.5	Loc'n of section	±.03	1_C7	Passed	1	Accepted
28	2.750	2 pl.	+0.010/-0.030	2_D7	2.747- 2.752	1	Accepted
29	R 0.25	4 pl.	±.03	2_D8	R .25 typ.	1	Accepted

INSPECTION / TEST REPORT					JOB No. 38025		
					PAGE: 2 of 3		
CUSTOMER: Dart Aerospace							
CUST. P.O. PO32459							
PART No. D5085-1				DESCRIPTION: Web			
DWG No. D5085 - sheets 1-2				REV. A		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

30	1.60	2 pl.	±.03	2_D7	1.604- 1.607	1	Accepted
31	.240		±.01	2_D8	.235	1	Accepted
32	R .06	4 pl.	±.03	2_C8	R .060 typ.	1	Accepted

SECTION B-B

33	96.10	Loc'n of section	±.03	1_C7	Passed	1	Accepted
34	2.381	2 pl.	+ .010/- .030	2_D5	2.386- 2.388	1	Accepted
35	R 0.50	4 pl.	±.03	2_D6	R .50 typ.	1	Accepted
36	1.89	2 pl.	±.03	2_D6	1.892 typ.	1	Accepted
37	.425		±.01	2_D6	.413 (stock)	1	Accepted
38	R .13	4 pl.	±.03	2_D6	R .125 typ.	1	Accepted
39	Linear taper	Sect. A-A to B-B	-	1_B8	Passed	1	Accepted

SECTION C-C

40	86.68	Loc'n of section	±.03	1_C6	Passed	1	Accepted
41	2.090	2 pl.	+ .010/- .030	2_D3	2.085- 2.087	1	Accepted
42	R 0.25	4 pl.	±.03	2_D4	R .25 typ.	1	Accepted
43	2.20	2 pl.	±.03	2_D4	2.194- 2.196	1	Accepted
44	.285		±.01	2_D4	.281	1	Accepted
45	R .15	4 pl.	±.03	2_C4	R .15 typ.	1	Accepted
46	Linear taper	Sect. B-B to C-C	-	1_B7	Passed	1	Accepted

SECTION D-D

47	74.68	Loc'n of section	±.03	1_C6	Passed	1	Accepted
48	2.090	2 pl.	+ .010/- .030	2_D1	R .25 typ.	1	Accepted
49	R 0.25	4 pl.	±.03	2_D2	R .25 typ.	1	Accepted
50	2.20	2 pl.	±.03	2_D2	2.085- 2.087	1	Accepted
51	.125		±.01	2_D2	.120	1	Accepted
52	R .15	4 pl.	±.03	2_C2	R .15 typ.	1	Accepted
53	Linear taper	Sect. C-C to D-D	-	1_B6	Passed	1	Accepted

SECTION E-E

54	53.68	Loc'n of section	±.03	1_C5	Passed	1	Accepted
55	2.941	2 pl.	+ .010/- .030	2_B7	2.938- 2.941	1	Accepted
56	R 0.25	4 pl.	±.03	2_B8	R .25 typ.	1	Accepted
57	1.41	2 pl.	±.03	2_C7	1.397- 1.399	1	Accepted
58	.125		±.01	2_B8	.120- .121	1	Accepted
59	R .030	4 pl.	±.01	2_B8	R .030 typ.	1	Accepted
60	Linear taper	Sect. D-D to E-E	-	1_B5	Passed	1	Accepted

INSPECTION / TEST REPORT						JOB No. 38025	
PAGE: 3 of 3							
CUSTOMER: Dart Aerospace							
CUST. P.O PO32459							
PART No. D5085-1				DESCRIPTION: Web			
DWG No. D5085 - sheets 1-2				REV. A		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

SECTION F-F							
43	32.95	Loc'n of section	±.03	1_C3	Passed	1	Accepted
44	2.941	2 pl.	+ .010/- .030	2_B5	2.942- 2.940	1	Accepted
45	R 0.25	4 pl.	±.03	2_B6	R .25 typ.	1	Accepted
46	1.41	2 pl.	±.03	2_C6	1.393- 1.403	1	Accepted
47	.125		±.01	2_B6	.123- .124	1	Accepted
48	R .030	4 pl.	±.01	2_B6	R .030 typ.	1	Accepted
49	Constant Section	Sect. E-E to F-F	-	1_B4	Passed	1	Accepted
SECTION G-G							
50	11.95	Loc'n of section	±.03	1_C2	Passed	1	Accepted
51	3.000	2 pl.	+ .010/- .030	2_B3	3.000- 3.003	1	Accepted
52	R 0.25	4 pl.	±.03	2_B4	R .25 typ.	1	Accepted
53	1.27	2 pl.	±.03	2_C4	1.260 typ.	1	Accepted
54	.125		±.01	2_B4	.123- .124	1	Accepted
55	R .030	4 pl.	±.01	2_B4	R .030 typ.	1	Accepted
56	Linear taper	Sect. F-F to G-G	-	1_B3	Passed	1	Accepted
SECTION H-H							
57	0.00	Loc'n of section	±.03	1_C1	Passed	1	Accepted
58	3.000	2 pl.	+ .010/- .030	2_B1	3.000- 3.003	1	Accepted
59	R 0.25	4 pl.	±.03	2_B2	R .25 typ.	1	Accepted
60	1.27	2 pl.	±.03	2_C2	1.264- 1.267	1	Accepted
61	.125		±.01	2_B2	.128- .129	1	Accepted
62	R .030	4 pl.	±.01	2_B2	R .030 typ.	1	Accepted
63	Constant Section	Sect. G-G to H-H	-	1_B1	Passed	1	Accepted